

Date: Monday, 02/03/2009 9:04:48 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : BUSHING

Job Number : 46132

Estimate Number : 10696

P.O. Number :

Part Number : D34547

This Issue : 02/03/2009 S.O. No. :

Drawing Number : D3454 REV B

Prsht Rev. : NC

Project Number : N/A

First Issue : / / Type : MACHINED PARTS

Drawing Revision : B

Previous Run : 44792

Material :

Written By :

Due Date : 09/03/2009 Qty: 60 Um: Each

Checked & Approved By : JUD 09.03.02

Comment : EST REV. A 05.11.17 New Issue EC

Est Rev:B 08-04-25 chg to revB DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

M303R0750

303 Round Bar 0.750



cl
M303R0750 = 31593
M10012 → 31 7/8 inches



Comment: Qty.: 0.0552 f(s)/Unit Total: 3.3138 f(s)

303 Round Bar .75"

(M303R0750)

Batch: M10012

SD 09/03/04
SD 09/03/05

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA573 & DWG D3454,

FOLIO REV: AADWG REV: B

SD 09/03/04
SD 09/03/05

2-DEBURR AS REQUIRED

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

see the next
page MF 09-03-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3454-7 PAR #: N/A Fault Category: Prod/Machined Parts NCR: (Yes) No DQA: D Date: 09/03/12
D412-630-031/032
 Resolution: _____ Disposition: _____ QA: N/C Closed: D Date: 09/03/12

NCR: <u>46132</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/3/5	# 1.0	50 parts made with wrong mat. & made with 304 instead of 303. Operator found that other shift operator grabbed the wrong Bar. R.C. LACK OF Attention.	UP 09.03.05 p.v. QSI/042	Acceptable Ensure to always verify the material being used.	UP 09/03/12		UP 09.03.05 p.v. QSI/042	S 09/03/05
					UP 09.03.05		UP 09.03.05 p.v. QSI/042	S 09/03/05

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 1:22:58 PM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 46132		
Estimate Number	: 10696		
P.O. Number	:	Part Number	: D34547
This Issue	: 23/03/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3454 REV B
First Issue	: 02/03/2009	Project Number	: N/A
Previous Run	: 44792	Drawing Revision	: B
		Material	:
Written By	:	Due Date	: 09/03/2009
Checked & Approved By	:	Qty:	60
Comment	: EST REV. A 05.11.17 New Issue EC Est Rev:B 08-04-25 chg to revB DD verified by:EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

HR 9-3-23



Job Completion



Date: Monday, 02/03/2009 9:04:48 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 46132

Part Number: D34547

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



location

Comment: INSPECT WORK TO CURRENT STEP

8 02/03/23

K60

7.0

PACKAGING 1

PACKAGING RESOURCE #1



60x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 96

9/3/23

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-03-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 4632
Description: Bushing		Part Number: D3454-7
Inspection Dwg: D3454	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.250	+0.005/-0.000	.251				
Ø0.372	+0.000/-0.005	.370				
0.343	+0.005/-0.000	.343				
0.060	+0.010/-0.000	.0625				
0.75	+/-0.030	.748				

Measured by: [Signature]	Audited by: mmf/jmk	Prototype Approval:	N/A
Date: 09/03/04	Date: 09/03/05	Date:	N/A

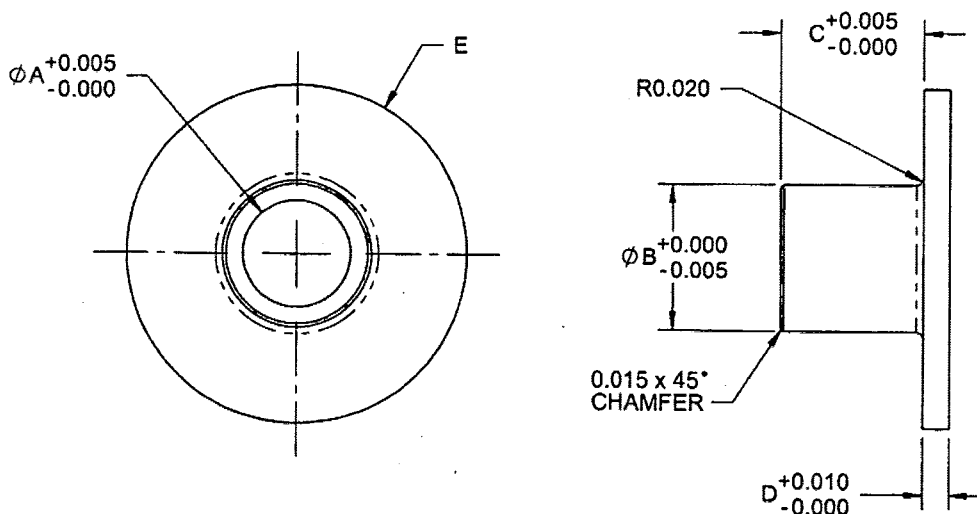
Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue	KJ/JLM	
B	07.11.23	Dimensions updated	KJ/EC/DD	[Signature]



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3454	REV. B SHEET 1 OF 1
DATE 05.12.05		TITLE BUSHING	SCALE 2:1
A	05.09.02	NEW ISSUE	
B	05.12.05	REVISE -5/-7	

RELEASED

05.12.05 *[Signature]*



D3454-X

1) SPECIFICATION: D3454-X BUSHING

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)	D (in)	E (in)
-1	0.316	0.435	0.420	0.060	1.00
-3	0.316	0.435	0.400	0.060	0.75
-5	0.250	0.372	0.400	0.060	0.75
-7	0.250	0.372	0.343	0.060	0.75



NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) IDENTIFY WITH P/N USING FINE POINT PERMANENT MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *46132*

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